

Tuesday, 01/05/2007 2:24:01 PM  
Linda Lacelle

## Process Sheet

Split 20705-16

Customer : CU-DAR001 Dart Helicopters Services  
Job Number : 31870-5  
Estimate Number : 12709  
P.O. Number : N/A  
This Issue : 01/05/2007 S.O. No. : *pk*  
Prsht Rev. : NC  
First Issue : *N/A* Type : LARGE FAB ASSY  
Previous Run : 31870

Drawing Name : GUIDE ASSEMBLY

Part Number : D3572041  
Drawing Number : D3572 REV.B  
Project Number : N/A  
Drawing Revision : B  
Material : *N/A*  
Due Date : 13/05/2007

Qty: 60 Um: Each

Written By :  
Checked & Approved By :  
Comment : Est Rev:A New Issue 07-02-07 JLM  
est rev B revB dwg EC

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description:

1.0 D35723 GUIDE



Comment: Qty.: 4.0000 Each(s)/Unit Total: 240.0000 Each(s) *32*  
GUIDE  
Batch: *B31912 = 117 B321782 =*

PD 07-05-15 (14)

2.0 D35727 CAP



Comment: Qty.: 2.0000 Each(s)/Unit Total: 120.0000 Each(s)  
CAP  
Batch: *B31914*

PD 07-05-15 (14)

3.0 D35725 BRACKET



Comment: Qty.: 1.0000 Each(s)/Unit Total: 60.0000 Each(s)  
BRACKET  
Batch: *B31913*

PD 07-05-15 (14)

4.0 M6061T6T1000W188 6061T6 TUBE 1.00 X .188W



Comment: Qty.: 2.3405 f(s)/Unit Total: 140.4270 f(s)  
6061-T6 Round Tube 1.00"x 0.188 wall  
Batch: *M18101 7.02*

104450

M18147

30.426

LE 07-05-14

X11

SUBSTITUTE 1" OD 6061-T6 ROD

27 07/05/11

5.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1  
1-Cut Tube D3572-1 as per Dwg D3572

3104480

27 07-05-14 (59)  
27 07/05/11/16





# Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GUIDE ASSEMBLY

Job Number: 31870

Part Number: D3572041

Job Number:



Seq. #:

Machine Or Operation:

Description :

2-Weld D3572-3 guides ,D3572-7 caps and D3572-5 bracket as per Dwg D3572  
A/R AL ROD Batch: M102756

3-Grind welds for end caps.

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

9.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

12.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Completion



U 07-05-16  
U 07-05-30



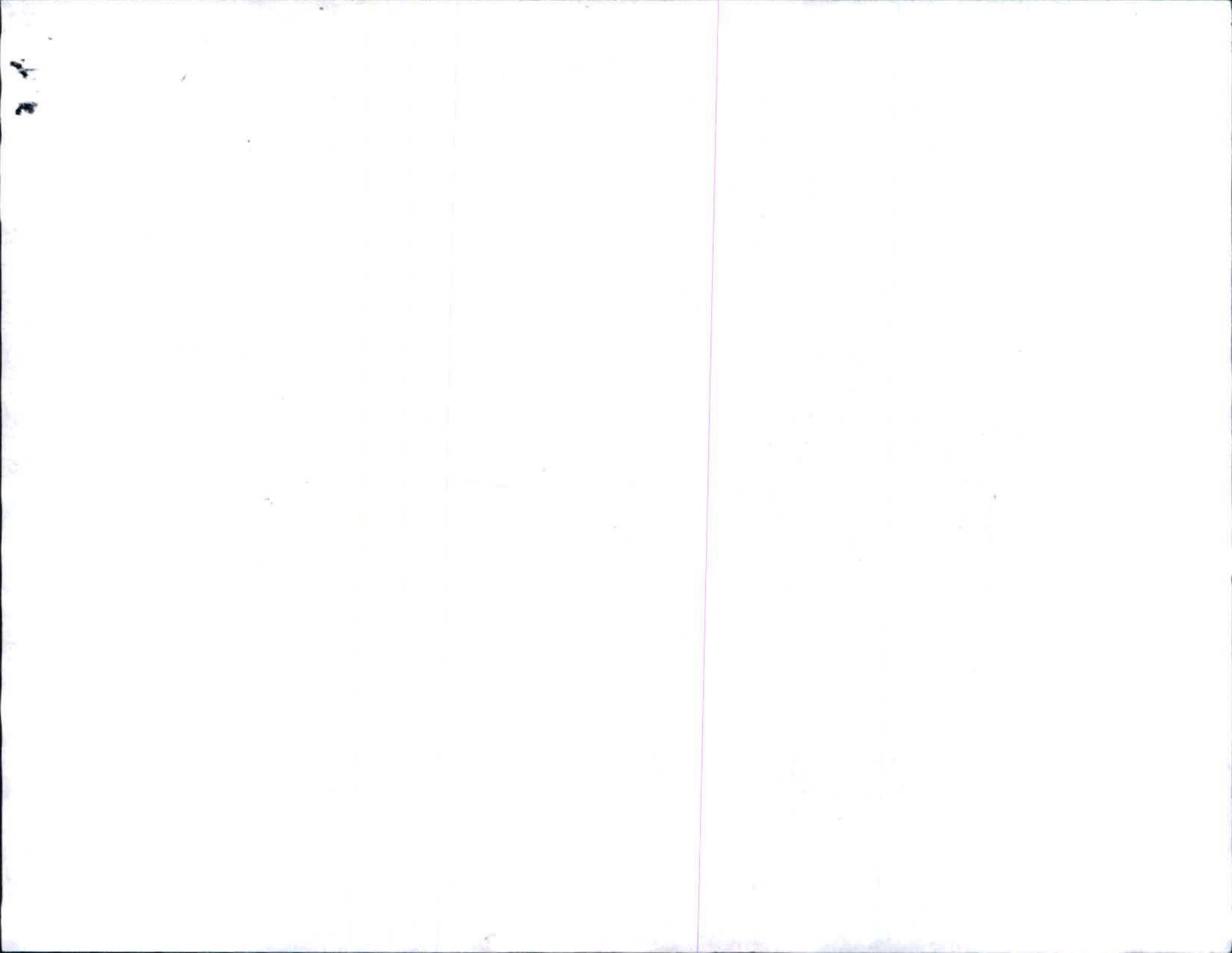


W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
07-05-16	10.0	W/O was split for a Qty of 8 on this w/o. 5 remaining on B31870-2 w/o.	2	07-05-16	8	2 07-05-16	2 07-05-16

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

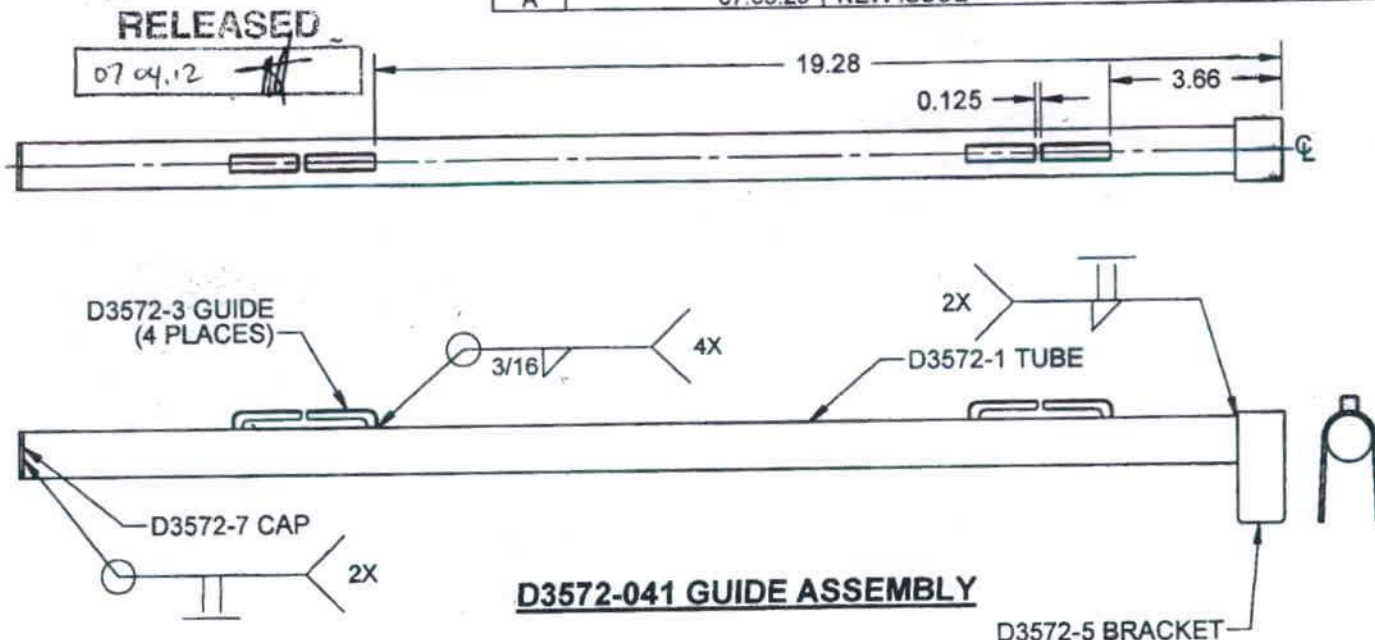
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07-05-15	5.0	The distance between the D3572-3 Guides varies from 0.140" → 0.160.	LE 07.05.16 SEE ATTACHED EMAIL FROM DS	ACCEPTABLE	LE 07-05-16 SEE ATTACHED EMAIL FROM DS.		LE 07-05-16	
07-05-15	5.0	1 X D3572-1 tube material was missing. No more left in stock.		Replace/substitute using, 1" OD 6061-T6 Solid Rod. → REQUIRED EXTRA HEATING AND WELD MATERIAL				
07-05-15	5.0	1 part took. Used for testing, with solid bar.	2 07-05-15	test & scrap, no replace.	LE 07-05-15	2 07-05-15	2 07-05-15	2 07-05-15

NOTE: Date & initial entries

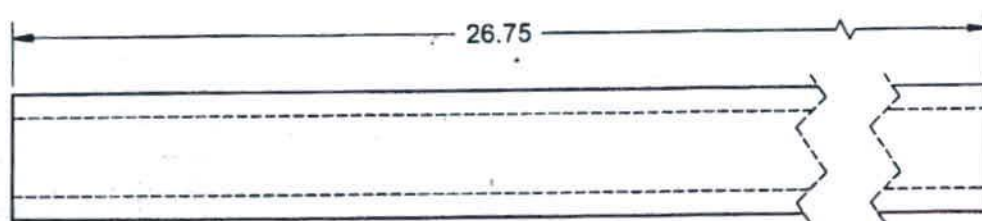


**DART**

DESIGN <i>LE</i>	DRAWN BY <i>LE</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3572</b>	REV. A SHEET 1 OF 2
DATE <b>07.03.29</b>	TITLE <b>GUIDE ASSEMBLY</b>		SCALE 1:4
REV A	DATE 07.03.29	DESCRIPTION NEW ISSUE	

**D3572-041 NOTES:**

- 1) PART IS SYMMETRIC ABOUT CENTERLINE
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3572-041" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) WELD PER DART QSI 004

**D3572-1 TUBE****D3572-1 NOTES:**

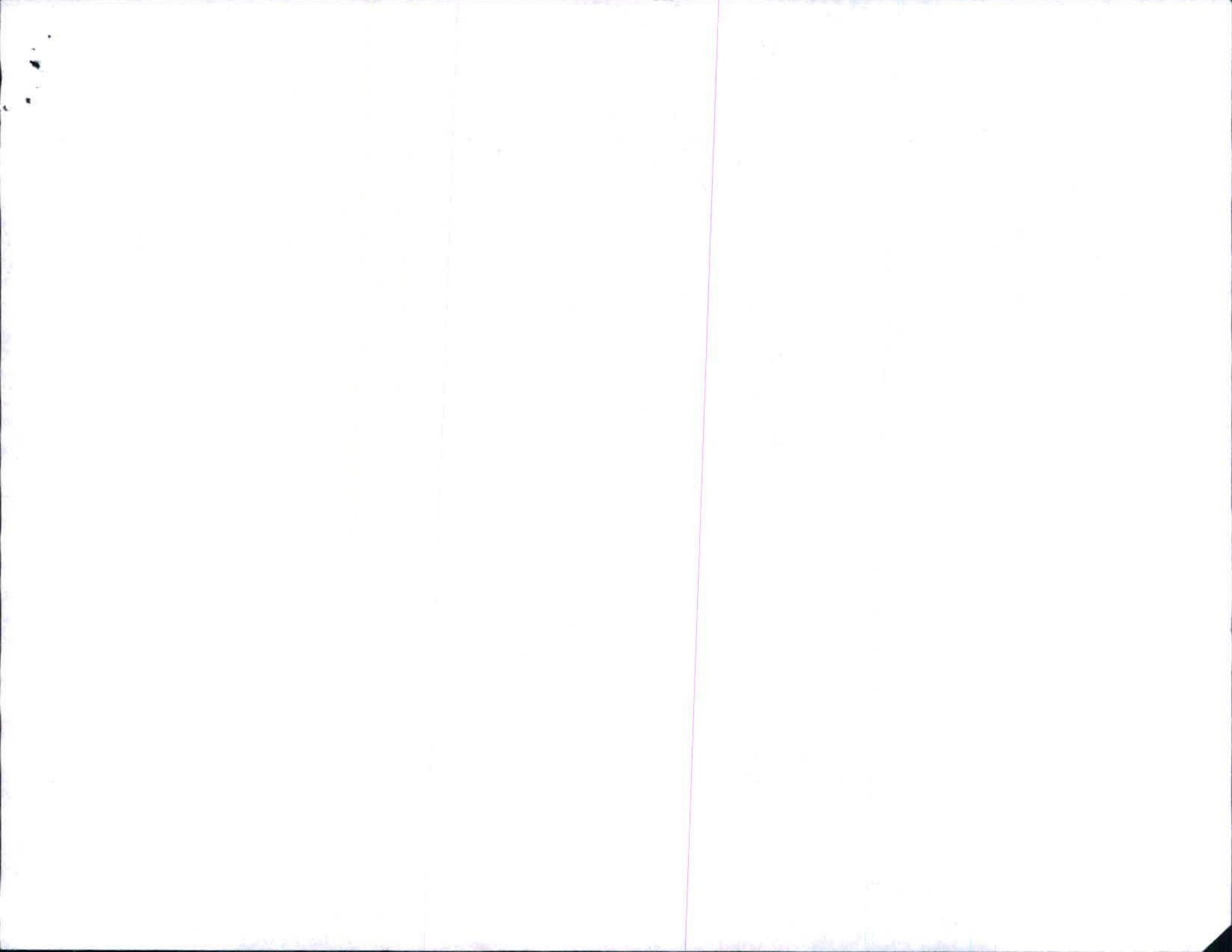
- 1) MATERIAL: 6061-T6 (OR T62) ALUMINUM TUBE 1.00 OD X 0.188 WALL  
PER WW-T-700/6 OR AMS 4080 OR AMS 4082 OR QQ-A-200/8 OR QQ-A-225/8  
(REF DART SPEC M6061T6T1.000W.188)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

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WORK ORDER  
NO. 31870

0.188 (REF)  $\phi$  1.000 (REF)

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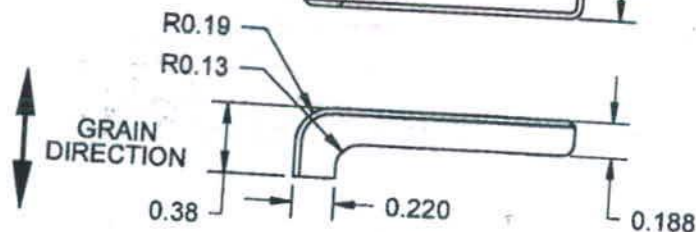
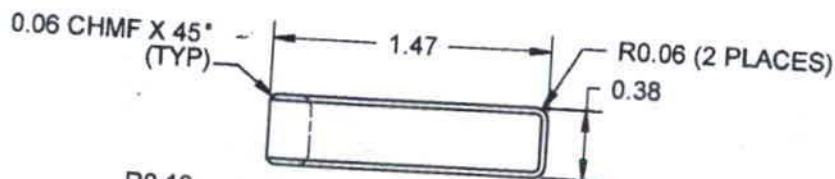
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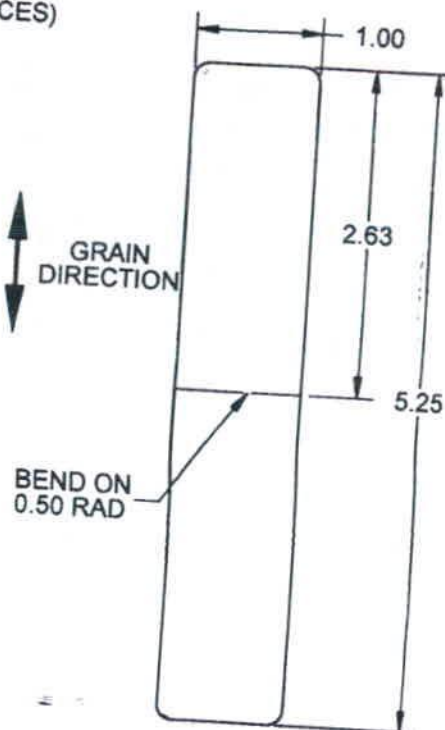


**DART**

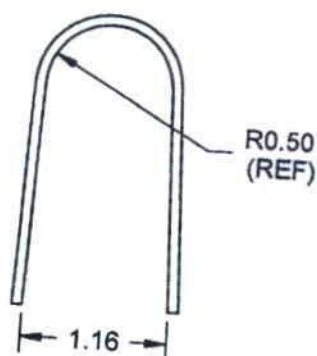
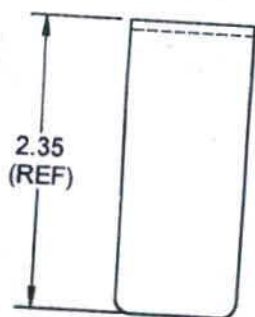
DESIGN <i>LE</i>	DRAWN BY <i>LE</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. <b>D3572</b>	REV. A
DATE <b>07.03.29</b>		TITLE <b>GUIDE ASSEMBLY</b>	SHEET 2 OF 2
			SCALE 2:3



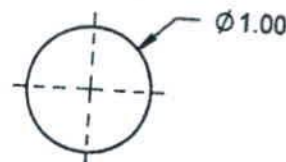
1 **D3572-3 GUIDE**

**RELEASED**07.04.12 *#*

2 **D3572-5F FLAT PATTERN**



**D3572-5 BRACKET**  
(MAKE FROM D3572-5F)



2 **D3572-7 CAP**

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WORK ORDER  
**31870**

**D3572-3/-5/-7 NOTES:**

- 1) D3572-3 MATERIAL: 6061-T6 (OR T651/T6510/T651/T62) ALUMINUM BAR PER QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR QQ-A-200/8 (OR AMS 4160) (REF DART SPEC M6061T6B)
- 2) D3572-5/-7 MATERIAL: 6061-T6 (OR T62) ALUMINUM SHEET 0.080 THICK PER QQ-A-250/11 OR AMS 4025 OR 4027 (REF DART SPEC M6061T6S.080)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

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